

Date: Tuesday, 06/01/2009 10:05:37 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HEAD REST ASSEMBLY RH
Job Number :	44409		
Estimate Number :	10867		
P.O. Number :		Part Number :	D412724044
This Issue :	06/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	//	Project Number :	N/A
Previous Run :	43040	Drawing Revision :	N/A
	Type :	Material :	
	SMALL /MED FAB	Due Date :	26/01/2009
Written By :		Qty:	4 Um: Each
Checked & Approved By :	JUD 09.01.06		
Comment :	Est Rev:A 04.09.08 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Handwritten: JUD 09/02/02

**Comment:** DOCUMENT CONTROL

If D412-724-044 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-724-044 CHG001

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D3303041	Head Rest
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3303-041 Head Rest 40839

Handwritten: SP

4.0	D3304044	Tube Assembly
-----	----------	---------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3304-044 Tube Assembly 42173

Handwritten: ③ 42109

Handwritten: SP

5.0	AN52510R6	Screw
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

Handwritten: 9/2/20

Handwritten: ④

Handwritten: SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAD REST ASSEMBLY RH

Job Number: 44409

Part Number: D412724044

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN525-10R6 Screw

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

placed in boxes.

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-724-044

Location:

PPP Rev:

DART

09/02/20 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/23

Job Completion



MF
09-02-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1.0 INTRODUCTION

These instructions cover the installation of Dart Replacement Head Rest Kits for the Bell 205/212/412 series aircraft. These kits can be procured to replace the existing head rests on the "4 man" aft facing seats as shown in Figure 1.

The D412-724-011 Replacement Head Rest Kit consists of (2) D412-724-041 Head Rest Assembly (replaces 205-072-701-101/-001/-005/-009/-019/-013/-105), (1) D412-724-043 Head Rest Assembly, LH (replaces 205-072-701-103/-003/-007/-011/-021/-015/-107) and (1) D412-724-044 Head Rest Assembly, RH (replaces 205-072-701-104/-004/-008/-012/-022/-016/-108).

It is acceptable to install the Head Rest Assemblies as an entire -011 kit or on an individual basis. Furthermore, D3304-041 replaces 205-072-702-101/-001, D3304-043 replaces 205-072-702-103/-003, D3304-044 replaces 205-072-702-104/-004, and D3303-041 replaces 204-070-723-101/-019.

The components in the Dart kits are as defined in the table in Section 5.0 of these instructions. For convenience, only the last three digits of the Part No. are listed on the top row of each table. The quantity of each component, which is included in the D412-724-011 Head Rest Kit, for example, is as defined in the column labeled -011.

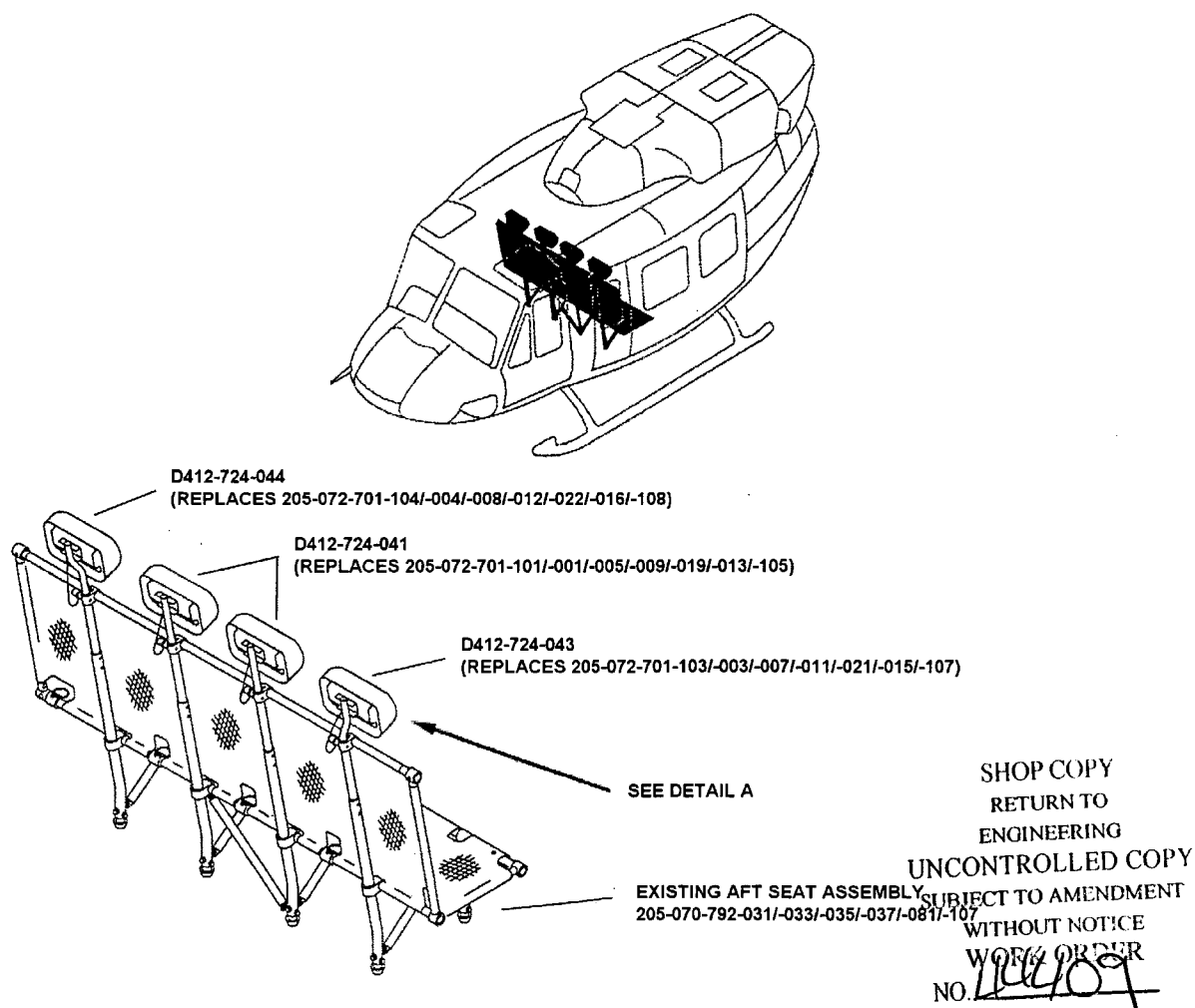


Figure 1 – Dart D412-724-011 Replacement Head Rest Kits

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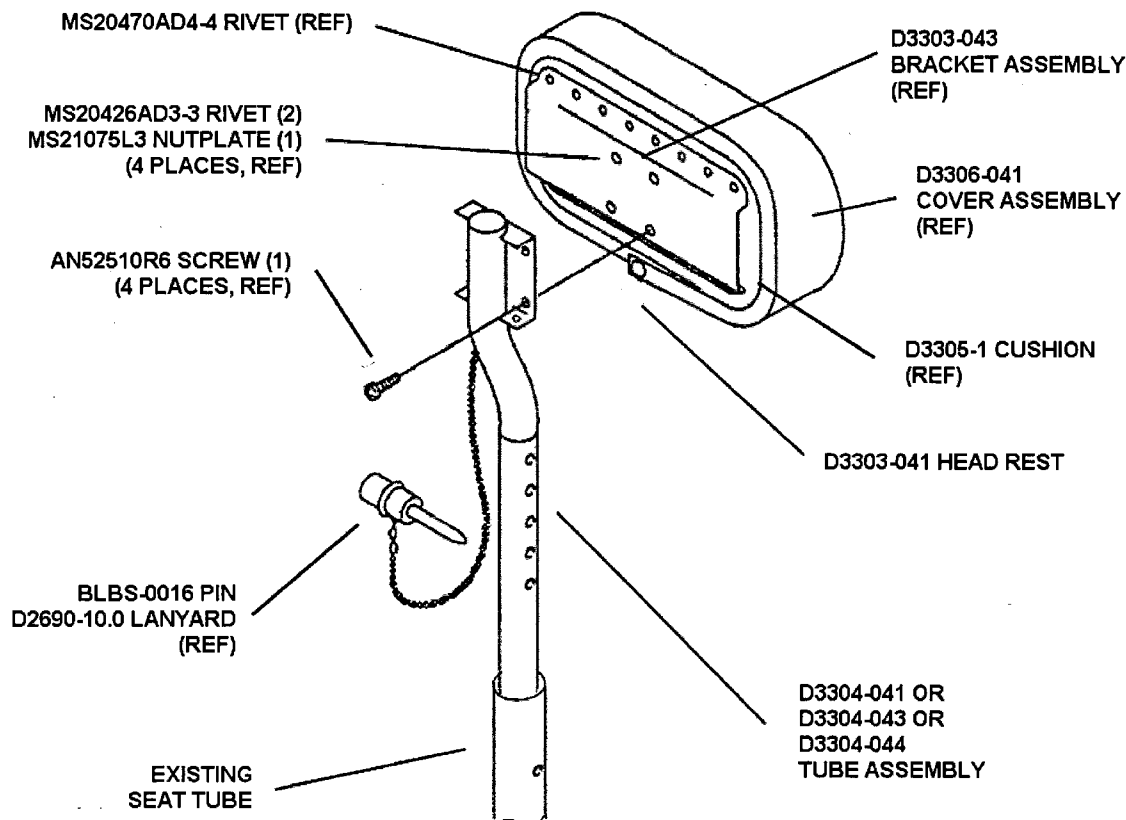


Figure 2 – Detail A Typical. Head Rest Assembly
(D412-724-044 Assembly shown, D412-724-041/-043 Similar)

2.0 GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

CONTINUING AIRWORTHINESS

These installations should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D412-724.

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3.0 INSTALLATION PROCEDURE

To install a Dart Head Rest Assembly:

- 3.1 If installed, remove the existing Head Rest Assembly by pulling the quick release pin that attaches it to the seat. Make note of the installation position (if applicable).
- 3.2 Inspect the seat for damage in the vicinity of the Head Rest Assembly. Consult the Aircraft Maintenance Manual for disposition if damage is observed.
- 3.3 If only replacing the Head Rest with the equivalent Dart D3303-041 Head Rest, separate the existing Head Rest from the existing Tube Assembly by undoing 4 screws. Re-assemble D3303-041 Head Rest with existing Tube Assembly by installing 4 screws and tightening to 15-25 in lb.
- 3.4 If only replacing the Tube Assembly with a Dart D3304-041/-043/-044 Tube Assembly, separate the existing Head Rest from the existing Tube Assembly by undoing 4 screws. Re-assemble existing Head Rest with Dart D3304-041/-043/-044 Tube Assembly by installing 4 screws and tightening to 15-25 in lb.
- 3.5 Slide the new or modified Head Rest Assembly into the seat tube and lock in place at the same location that the old Head Rest Assembly was installed (if applicable) using the quick release pin. Ensure pin is properly engaged.

4.0 WEIGHT AND BALANCE

There is negligible weight change associated with the installation of the Dart Head Rests.

5.0 PARTS LIST

QTY -011	QTY -041	QTY -043	QTY -044	Part Number	Description
X				D412-724-011	Dart Replacement Head Rest Kit, for 205/212/412
2	X			D412-724-041	Head Rest Assembly, Center
1		X		D412-724-043	Head Rest Assembly, LH
1			X	D412-724-044	Head Rest Assembly, RH
	1	1	1	D3303-041	Head Rest
	1			D3304-041	Tube Assembly
		1		D3304-043	Tube Assembly
			1	D3304-044	Tube Assembly
	4	4	4	AN525-10R6	Screw

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